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CLAIMS

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3     1. (Currently Amended) A clamping system for securing a first surface  
4     of a work piece against a frame, the clamping system comprising:

5                 a plurality of end supports, each of the end supports being configured to  
6                 be coupled to an anchor;

7                 one or more force applying units, each of the force applying units unit  
8                 including a body and a plunger movably coupled to the body and  
9                 adapted to apply a clamping force to a second surface of the work  
10                 piece to secure the first surface of the work piece against the frame;  
11                 and

12                 one or more coupling units linked with the one or more force applying  
13                 units forming a chain of force applying units and coupling units  
14                 between the plurality of end supports to support the force applying  
15                 units against a second surface of the work piece opposite the first  
16                 surface, each coupling unit including a lockable pivot, the lockable  
17                 pivot adapted to pivot to conform the chain to a surface of the work  
18                 piece when unlocked, and adapted to be locked when at least one of  
19                 the force applying units applies the clamping force to the work  
20                 piece.

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22     2. (Original)         The clamping system of Claim 1, wherein the lockable  
23                 pivot includes a bendable elbow.

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1       3. (Withdrawn)      The clamping system of Claim 2, wherein the bendable  
2       elbow includes interlocking teeth, arranged to interlock when the lockable pivot is  
3       locked.

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5       4. (Original)      The clamping system of Claim 1, wherein the lockable  
6       pivot includes a ball and socket.

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8       5. (Withdrawn)      The clamping system of Claim 1, wherein the lockable  
9       pivot is manually lockable.

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11      6. (Withdrawn)      The clamping system of Claim 5, wherein the lockable  
12       pivot includes a twist to lock mechanism.

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14      7. (Original)      The clamping system of Claim 1, wherein the lockable  
15       pivot is externally powered.

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17      8. (Original)      The clamping system of Claim 1, wherein the lockable  
18       pivot unit is electrically powered.

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20      9. (Withdrawn)      The clamping system of Claim 1, wherein the lockable  
21       pivot unit is hydraulically powered.

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23      10. (Withdrawn)     The clamping system of Claim 1, wherein the lockable  
24       pivot unit is pneumatically powered.

1        11. (Original)        The clamping system of Claim 1, wherein the lockable  
2 pivot includes a solenoid.

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4        12. (Original)        The clamping system of Claim 1, wherein the force  
5 applying unit includes a threaded plunger, threadedly connected with the body.

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7        13. (Withdrawn)      The clamping system of Claim 1, wherein the force  
8 applying unit is manually operated.

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10       14. (Original)        The clamping system of Claim 1, wherein the force  
11 applying unit is externally powered.

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13       15. (Original)        The clamping system of Claim 1, wherein the force  
14 applying unit is electrically powered.

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16       16. (Withdrawn)      The clamping system of Claim 1, wherein the force  
17 applying unit is hydraulically powered.

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19       17. (Withdrawn)      The clamping system of Claim 1, wherein the force  
20 applying unit is pneumatically powered.

1       18. (Withdrawn)     The clamping system of Claim 1, further comprising:  
2                          at least one length adjusting unit attached to and interspersed with the  
3                          one or more force applying units and the one or more coupling units,  
4                          the length adjusting unit arranged to adjustably change length to  
5                          adjust a length of the chain.

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7       19. (Withdrawn)     The clamping system of Claim 18, wherein the length  
8                          adjusting unit is externally powered.

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10      20. (Withdrawn)     The clamping system of Claim 18, wherein the length  
11                          adjusting unit includes a turnbuckle.

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1        21. (Currently Amended) A clamping system for securing a first surface  
2 of a work piece against a frame during manufacturing, the clamping system  
3 comprising:

4        a plurality of end supports, each of the end supports being configured to  
5        support the clamping system against the work piece;  
6        one or more externally powered force applying units, each powered  
7        force applying unit including a body and a plunger movably attached  
8        to the body arranged to apply a clamping force to a work piece; and  
9        one or more elbow units, each elbow unit including a lockable pivot,  
10        attached to and interspersed with the one or more force applying  
11        units forming a chain of force applying units and elbows between the  
12        plurality of end supports, the lockable pivot arranged to pivot to  
13        conform the chain to a surface of the work piece when unlocked, and  
14        arranged to lock when the force applying unit applies the clamping  
15        force to the work piece.

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17        22. (Withdrawn) The clamping system of Claim 21, wherein the  
18 bendable elbow includes interlocking teeth, arranged to interlock when the  
19 lockable pivot is locked.

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21        23. (Withdrawn) The clamping system of Claim 21, wherein the  
22 lockable pivot is manually lockable.

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24        24. (Withdrawn) The clamping system of Claim 23, wherein the  
25 lockable pivot includes a twist to lock mechanism.

1        25. (Original)        The clamping system of Claim 21, wherein the  
2 lockable pivot is externally powered.

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4        26. (Original)        The clamping system of Claim 21, wherein the  
5 lockable pivot is electrically powered.

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7        27. (Withdrawn)      The clamping system of Claim 21, wherein the  
8 lockable pivot is hydraulically powered.

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10       28. (Withdrawn)      The clamping system of Claim 21, wherein the  
11 lockable pivot is pneumatically powered.

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13       29. (Original)        The clamping system of Claim 21, wherein the  
14 lockable pivot includes a solenoid.

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16       30. (Original)        The clamping system of Claim 21, wherein the force  
17 applying unit is includes a threaded plunger, threadedly connected with the body.

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19       31. (Original)        The clamping system of Claim 21, wherein the force  
20 applying unit is electrically powered.

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22       32. (Withdrawn)      The clamping system of Claim 21, wherein the force  
23 applying unit is hydraulically powered.

1       33. (Withdrawn)      The clamping system of Claim 21, wherein the force  
2 applying unit is pneumatically powered.

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4       34. (Withdrawn)      The clamping system of Claim 21, further comprising:  
5                  at least one length adjusting unit attached to and interspersed with the  
6                  one or more force applying units and the one or more coupling units,  
7                  the length adjusting unit arranged to adjustably change length to  
8                  adjust a length of the chain.

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10      35. (Withdrawn)      The clamping system of Claim 34, wherein the length  
11     adjusting unit is externally powered.

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13      36. (Withdrawn)      The clamping system of Claim 34, wherein the length  
14     adjusting unit includes a turnbuckle mechanism.

1       37. (Withdrawn)     A clamping system for manufacturing, the clamping  
2 system comprising:

3                 one or more force applying units, each force applying unit including a  
4                 body and a plunger movably attached to the body arranged to apply  
5                 a clamping force to a work piece; and  
6                 one or more multi-axis pivot units, each multi-axis pivot unit including  
7                 a lockable multi-axis pivot, attached to and interspersed with the one  
8                 or more force applying units forming a chain of force applying units  
9                 and pivot units, the lockable multi-axis pivot arranged to pivot in a  
10                 plurality of axes to conform the chain to a surface of the work piece  
11                 when unlocked, and arranged to lock when at least one of the one or  
12                 more force applying units applies the clamping force to the work  
13                 piece.

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15       38. (Withdrawn)     The clamping system of Claim 37, wherein the  
16 lockable multi-axis pivot includes interlocking teeth, arranged to interlock when  
17 the lockable multi-axis pivot is locked.

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19       39. (Withdrawn)     The clamping system of Claim 37, wherein the  
20 lockable multi-axis pivot includes a ball and socket.

1       40. (Currently Amended) A clamping system for manufacturing, the  
2 clamping system comprising:

3             one or more force applying units, each force applying unit including a  
4             body and a force applying member movably attached to the body  
5             arranged to apply a clamping force to a work piece, wherein the  
6             force applying members are configured to be laterally  
7             simultaneously motivated by an externally-powered force unit that  
8             drives the force applying member relative to the body; and  
9             one or more coupling units operatively coupled to the force applying  
10            units, each coupling unit including a movable pivot, attached to and  
11            interspersed with the one or more force applying units forming a  
12            chain of force applying units and coupling units.

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14       41. (Original) The clamping system of Claim 40, wherein the movable pivot  
15 includes a bendable elbow.

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17       42. (Original) The clamping system of Claim 40, wherein the pivot includes  
18 a ball and socket.

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20       43. (Withdrawn) The clamping system of Claim 40, wherein the force  
21 applying unit is manually operated.

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23       44. (Canceled).

1       45. (Original)           The clamping system of Claim 40, wherein the force  
2 applying unit is electrically powered.

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4       46. (Withdrawn)       The clamping system of Claim 40, wherein the force  
5 applying unit is hydraulically powered.

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7       47. (Withdrawn)       The clamping system of Claim 40, wherein the force  
8 applying unit is pneumatically powered.

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10      48. (Withdrawn)       The clamping system of Claim 40, further comprising:  
11           at least one length adjusting unit attached to and interspersed with the  
12           one or more force applying units and the one or more coupling units,  
13           the length adjusting unit arranged to adjustably change length to  
14           adjust a length of the chain.

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16      49. (Withdrawn)       The clamping system of Claim 48, wherein the length  
17           adjusting unit is externally powered:

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19      50. (Withdrawn)       The clamping system of Claim 48, wherein the length  
20           adjusting unit includes a turnbuckle mechanism.

1       51. (Withdrawn)     The clamping system of Claim 40, further comprising:  
2                          a first end support attached to a first end of the chain, arranged to  
3                          securely hold the first end of the chain when the clamping force is  
4                          applied; and

5                          a second end support attached to a second end of the chain, arranged to  
6                          securely hold the second end of the chain when the clamping force is  
7                          applied.

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9       52. (Currently Amended)   A clamping system for clamping a work piece  
10      during manufacturing, the system comprising:

11                       one or more force applying means arranged to apply a clamping force to  
12                       the work piece, wherein the force applying means are configured to  
13                       be laterally simultaneously motivated by an externally-powered  
14                       means for powering the force applying means configured to drive  
15                       the force applying member relative to the body; and

16                       one or more pivoting means arranged in a chain with the one or more  
17                       force applying means, the pivoting means arranged to pivot to  
18                       conform the chain to a surface of the work piece.

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20       53. (Original)     The apparatus of Claim 52, further comprising means  
21      for powering the force applying means.

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23       54. (Original)     The apparatus of Claim 52, further comprising means  
24      for locking the pivoting means.

1        55. (Original)              The apparatus of Claim 54, further comprising means  
2 for powering the means for locking the pivoting means.

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4        56. (Withdrawn)          The apparatus of Claim 52, further comprising at least  
5 one length adjusting means, arranged in the chain with the one or more force  
6 applying means and the one or more pivoting means to adjust the length of the  
7 chain.

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9        57. (Withdrawn)          A method for clamping during a manufacturing  
10 operation on a work piece, comprising:

11              positioning a chain of a one or more coupling units and one or more force  
12              applying units against the work piece thereby conforming the chain to  
13              a surface contour of the work piece; and  
14              applying clamping force to the work piece along the chain by engaging  
15              the force applying units.

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17        58. (Withdrawn)          The method of Claim 57, further comprising locking at  
18              least one of the one or more coupling units with the chain conforming to the  
19              surface contour.

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21        59. (Withdrawn)          The method of Claim 57, further comprising  
22              tensioning the chain across the workpiece.

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24        60. (Withdrawn)          The method of Claim 57, further comprising adjusting  
25              the length of the chain.